

Monday, 22/09/2008 12:54:40 PM

Julie Lecocq

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 42169

**Estimate Number** 

: 10897

P.O. Number

: 22/09/2008

This Issue Prsht Rev.

: NC

First Issue **Previous Run** 

: 11

S.O. No. :

Туре

: MACHINED PARTS

: 41028

Written By Checked & Approved By

Comment

: Est Rev:F

Re-format

05-11-22

Part Number

**Drawing Name** 

: D2618

: N/A

: BUSHING

**Drawing Number** 

: D2618 REV B1

**Project Number** 

: B1 **Drawing Revision** 

Material **Due Date**  : ,N/A : 29/09/2008

Qty:

200 Um:

Each

Additional Product

Job Number:



Seq. #:

**Machine Or Operation:** 

Description: Delrin Round Bar 0.75"

MDELRINR0750



Comment: Qty.:

0.2709 f(s)/Unit Total: 54.1800 f(s)

Delrin Round Bar .75" black

JLM

2.0



Batch: **M 1091** 

Comment: HARDINGE CNC LATHE SMALL

\$ 08/08/25

1-Turn as per Folio FA195 & Dwg D2618.

2-Deburr

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK





QC8

Comment: SECOND CHECK

5.0

4.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

Page 1

Form: rprocess

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHA	ANGES	•			
DATE	STEP	PROCEDURE CHANGE		By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: <u>D2618</u>	PAR #: NA	Fault Category: Pod /	Madrised April N	NCR: (es) No		
Resolution:		Disposition:		A: N/C Closed	$\mathcal{A}$	Date: 68/8/3

NCR:42	2169	W	ORK ORI	DER NON-CONFORMANC	E (NCR)			
DATE	STEP	Description of NC		Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
40/25	2.0	\$50 parts sciap.	P	SCRAP + Replace Bit M109183 Paty (48)	m>		9	
Get.	20	Human forester error operator ports Dolls mesons port wrety	08.09.29	Bi M109183 QH (48)	08/w/30	201 0/20	08.09.28 p~	al da
		oprahr Doch	QS1 642			ordalia	DSJon (	D(01/21
		merond pot cornelly	:					
						21-1-1-1		

Date: User: Monday, 22/09/2008 12:54:40 PM

Julie Lecocq

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 42169

Part Number: D2618

Job Number:



Seq. #:

TABLE / WINE CO

**Machine Or Operation:** 

**Description:** 

6.0

QC21

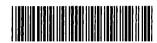
FINAL INSPECTION/W/O RELEASE



08/09/30

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-3

## **Dart Aerospace Ltd**

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								From Wigi	
Part No	•	PAR #:	Fault Cate	Jory:	NCR: Yes	No <b>DQ</b>	⊥ A:	Date:	
		esolution:							
NCR:		V	VORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			ion B		ation	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
				•					
l	1	1	1 1		ŀ	I		I	1

DART AEROSPACE LTD	Work Order:	42169
Description: Bushing	Part Number:	D2618
Inspection Dwg: D2618 Rev: B1		Page 1 of 1

	FIRS	T ARTICLE II	NSPECTI	ON CH	ECKLIST		
	X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	C	omments
3.100	+/-0.010	3.099	· V				
Ø0.500	+0.000/-0.010	Ø. 503 K					
Ø0.313	+0.020/-0.000	Ø.314 °	\ \				
		6,489	A 08	<i>E</i> V2	\$		
							· <u>-</u>
		,	•				
				<u> </u>			
Measured by:	Me Ish	Audited by:	and	)	Prototype Ap	proval:	N/A

Measured by:	mus S	Audited by:	and	Prototype Approval:	N/A
Date:	25/09/23	Date:	08/09/29	Date:	N/A
		~ 12 V	,		

Rev	Date	Change 66/01	Revised by	Approved
Α	04.08.26	New Issue	KJ/JLM	1
В	04.09.10	Changed tolerance for Ø0.500	KJ/JLM 🔏	

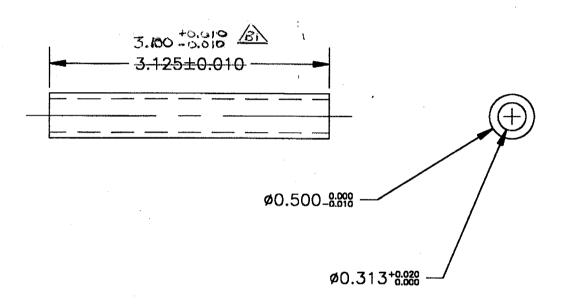
Dart Aeı	ospace	Ltd							
W/O:			WC	RK ORDER CHANGE	ES				
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							ļ		
Part No.		PAR #:	Fault Cate	norv:	NCR: Ves	No DOA:		Date:	
1 411 140		esolution:							
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR	3)			
DATE	0750	Description of NC		Corrective Action Section		Verifica	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector





DESIGN BW	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
BW	BW	D2618 SHEET	1 OF 1
DATE		MLE	SCALE
96:10:30		BUSHING	1:1
В	97.05.09	3.125 WAS 1.625, .313 WAS .375	
BI WH	04.06.03	CHANGE DIM FOR BETTER FIT	

RELEASED 91/05/13 DS



MATERIAL: DELRIN OR TEFLON OR NYLON

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

Approval QC Inspector
•
Approval
QC Inspector
•
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